

Work Order ID 81044

81044

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March-07-12 7:45:51 AM

Item ID: D2432 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206 (24") Bearpaw
 Start Date: 07/03/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 21/03/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
120	FLOW WATER JET	0.00							
120									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130	HAAS CNC VERTICAL MACHINING #1	0.00							
130									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 12-03-13 (2)

PO 12/03/15

PO 12/03/15

2 0
2 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: <u>499</u>	0.00							
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

OK 12/03/19

2

12/13/20

12/13/26
MF
12-03-23

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 81044

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Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	573.6043	3.7	7.4			
**													
MUHMWB10													
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT018

316.48

120035

74.48

120401

242

MAT019

257.1243158

117321

74.6

117738

93.28

117819

83.3

118814

1.5

119145

4.44431579

NW 12-03-13

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	81044
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		VERN	GA-09
B	5.500	+/-0.030	5.500	✓		"	"
C	0.200	+/-0.030	0.202	✓		"	"
D	0.25 x 45°	+/-0.030	0.250 x 45°	✓		"	"
E	R0.250	+/-0.030	0.250	✓		Radius G.	
F	0.250	+/-0.010	0.240	✓		Mic	118120
G	0.625	+/-0.030	0.615	✓		VERN	GA-09
H	0.375	+/-0.010	0.375	✓		Mic	118120
I	0.950	+0.030/0.010	0.940	✓		VERN	GA-09
J	19.000	+/-0.030	19.000	✓		M-TAPE	
K	3.14	+/-0.030	3.14	✓		VERN	GA-09
L	3.28	+/-0.030	3.28	✓		"	"
M	Ø0.260	+0.005/-0.000	0.260	✓		PIN G.	
N	Ø0.93	+/-0.030	0.925	✓		VERN	GA-09
O	0.30	+0.030/-0.000	0.310	✓			GA-09
P	23.750	+/-0.030	23.750	✓		M-TAPE	
Q	7.375	+/-0.030	7.375	✓		H-G.	
R	4.250	+/-0.010	4.252	✓		VERN	GA-09
S	2.000	+/-0.030	1.990	✓		"	"
T	9.000	+/-0.010	9.000	✓		H-G	
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	0.378	✓		VERN	GA-09

Measured by: PD / <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 12/03/15	Date: 12/03/19	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>

Dart Aerospace Ltd

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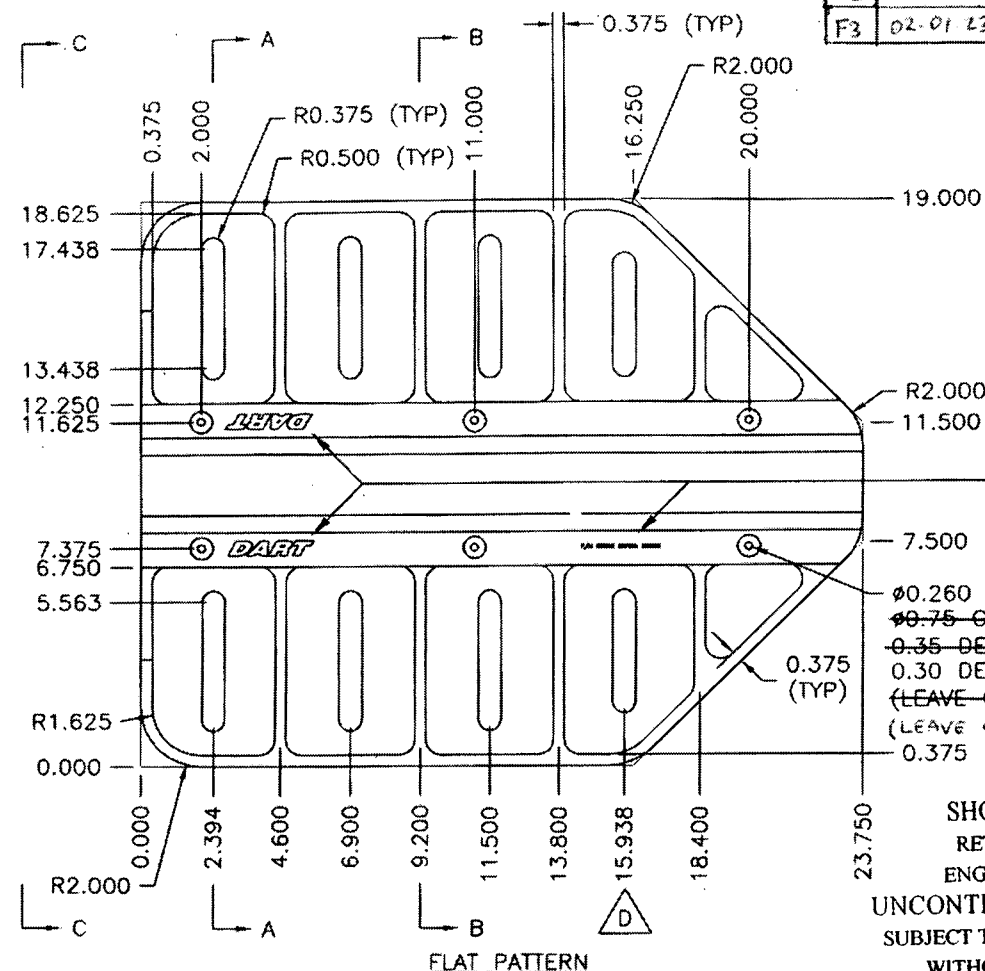
NOTE: Date & initial all entries

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F1	99.03.03	ADD DEO 9143
F2	01.03.28	00.93 WAS 00.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
99.06.17 KE

DART



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 80144/MCS

0.950 (REF) 12/05

EFFECTIVE DEOS

9143	
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D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
MM	AS	D2432	
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

Dart Aerospace Ltd

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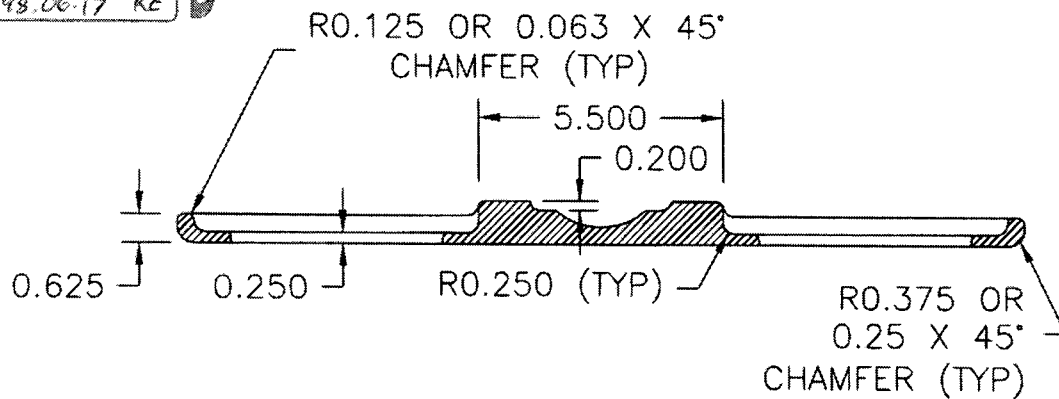
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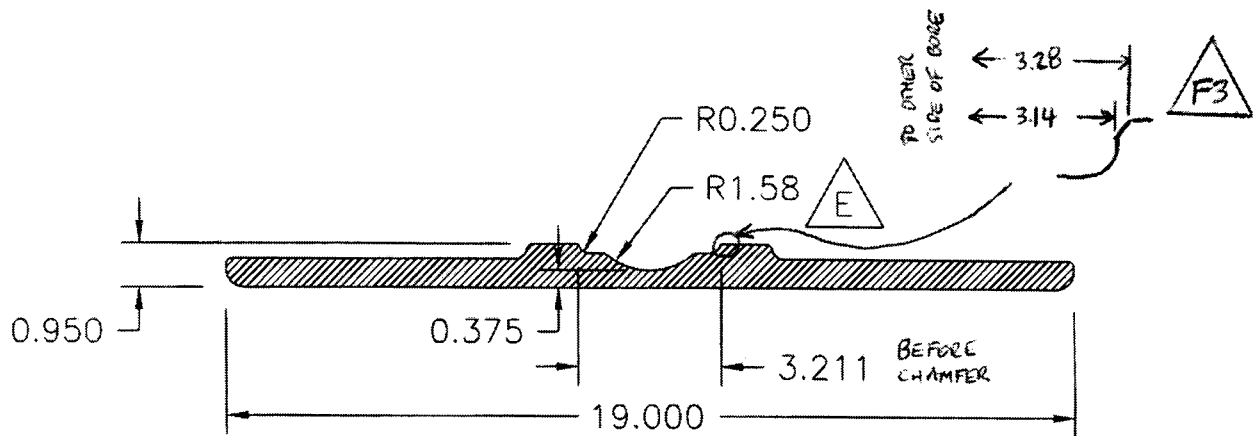


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

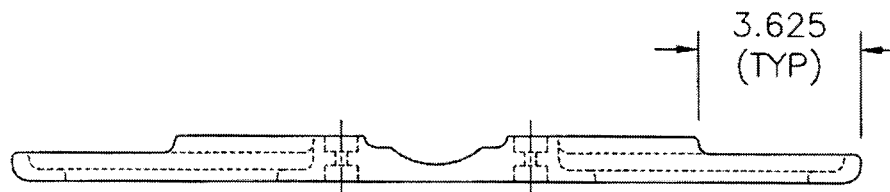
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

81044

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